

Date: Thursday, 5/10/2007 2:25:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 32274
 Estimate Number : 10943
 P.O. Number : *N/A*
 This Issue : 5/10/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : 31638
 Part Number : K10004
 Drawing Number : K10004 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 5/30/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : *07.05.10*
 Comment : Est: D 05.07.22 Reformat; Added D3428-3 per CHG003 K
 J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP K10004 for D205-594-011/-013 CHG003

CL KS 07.05.11

2.0 D205641011 GHW Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 GHW Kit

Qty	Part Number	Description	Batch
2	D205-641-011	GHW Kit	<i>B 31649 IN T B32275</i>

B 31649 IN T B32275

3.0 D2570 Bushing



Comment: Qty.: 32.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
32	D2570	Bushing	<i>B 30811</i>

B 30811

4.0 D2968041 Tow Ring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
2	D2968-041	Tow Ring	<i>B 29791</i>

B 29791

07/06/280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34283

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Placard

Pick:

Qty	Part Number	Description	Batch
1	D3428-3	Placard	B25850

6.0

D5951

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle

Pick:

Qty	Part Number	Description	Batch
2	D5951	Saddle	B32300

7.0

D5953

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle

Pick:

Qty	Part Number	Description	Batch
2	D5953	Saddle	B32301

8.0

D5955

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle

Pick:

Qty	Part Number	Description	Batch
2	D5955	Saddle	B31530

9.0

D5957

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle

Pick:

Qty	Part Number	Description	Batch
2	D5957	Saddle	B32303

31531

EP 07/06/284

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN451A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

16 AN4-51A Bolt

M103684 X

11.0

AN515A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

32 AN5-15A Bolt

M104118 614 M104547 674

12.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number Description Batch

2 AN5-36A Bolt

M104322 J

13.0

AN542A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN5-42A Bolt

M16762 J

14.0

AN543A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN5-43A Bolt

M104118 J C/S 7/6/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 32274

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

AN545A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN5-45A	Bolt	M101780

16.0

AN960JD516

Washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 320.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
80	AN960JD516	Washer	M103694

17.0

AN9704

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN970-4	Washer	M103344

18.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 72.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
18	MS21042L4	Nut	M102552

19.0

MS21042L5

Nut



Comment: Qty.: 40.0000 Each(s)/Unit Total : 160.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
40	MS21042L5	Nut	M103446

CP 5/10/07/280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32274

Part Number: K10004

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

④ 7/6/28 SQ C207/06/28(4)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Per E 7/6/28 SQ (4)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④ 7/07/06/29

Job Completion



U 07.06.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. K10004	REV. C SHEET 1 OF 1
DATE 05.07.22		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	05.07.22	ADD D3428-3 PLACARD	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015
D205-641-011	2	2	2
D2570	32	32	32
D2707-041 (OR D2968-041)	2	2	2
D3428-3*	1	N/A	1
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
**AN960JD1016	2	2	2
AN970-4	2	2	2
MS21042-4 (OR L4)	18	18	18
MS21042-5 (OR L5)	40	40	40

*REQUIRED WITH D205-594-011/-013/-015 INSTALLATIONS ON 214 AIRCRAFT ONLY

**REQUIRED WITH D2707-041 ONLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32274

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